



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18608-2
Job Sheet 199122



Part No: RBT18608-2

Job Qty: 1 pcs

DAS
21
9-89

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/7/19

Type: SOLD

Description:

Note: DWG RBT18608 Rev 2A IPP Rev. A 19.08.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Large Fab - Welded Assy-1	1 pcs	10/7/19		0.00	0.33	Large Fab - 1	<i>BL</i>
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
110	QC 9	1 pcs	10/7/19		0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	DAS
							QC 9 - 43	24
							QC 9 - 50	9-89
							QC 9 - 9	
120	QC 5	1 pcs	10/7/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	DAS
							QC 5 - 24	24
							QC 5 - 3	9-89
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	



Container No: S219414



Part: RBT18608-2

Job No: 199122

Serial No/Batch: S219414

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 10/03/19

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				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130	Outsource - 4 - Anodize	1 pcs	10/7/19	0.00 0.00	QC 002-VC #G001 2019-10-4
140	Packaging 2-1 - Recelve - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
150	QC 6	1 pcs	10/7/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
160	Packaging 3-1 - Stock - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B

DP OCT 21 2019

DAS
OCT 23 2019 68
9-89DAS
28
9-89PUSHED THROUGH BY
PAT. DUVAL

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	LAG
170 QC 21 - SA	1 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89

OCT 24 2019 6A149A

Part Op 100 - Weld as per drawing.
 Descriptions: 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - Issue P/O; 44694 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -
 Material type; 6061T6 -Certificate of Conformity is required
 140 - (Receive & Inspect for Damage & Mat'l Certs)
 150 - (QC6- All purchased or subcontracted products)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM					012238
Part / Item	Component Name	Quantity	Operation	Container	
RBT18608-1	Bottom	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5212047	
RBT18608-3	Support	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5212044	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	RBT18608-1 6A149	1	0	0
	RBT18608-3	1	0	0

Part Specifications	
Specifications could not be found.	

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Technical drawing of a rectangular plate with dimensions and a central hole. The plate is 2.25 inches wide and 2.25 inches high. A central hole has a diameter of 0.125 inches and a length of 1.125 inches. The hole is positioned 1.125 inches from the top and bottom edges and 0.50 inches from the left and right edges. The hole is labeled "RBT18608" and "PF-3". The plate is labeled "ENGRAVE T/N, S/N, 'MADE IN USA,'" and "BOTTOM".

Technical drawing of a rectangular plate. The overall width is 1.175 and the overall height is 1.25. There are two circular features, each with a diameter of $\phi .125$ (x2). The distance from the left edge to the center of the first feature is .375, and the distance from the center of the first feature to the center of the second feature is .100. The distance from the center of the second feature to the right edge is .313. A dimension line indicates a distance of .313 from the right edge to the center of the second feature. A note (3) indicates a support feature.

Technical drawing of a mechanical assembly. The drawing shows a cross-section of a component with various dimensions and callouts. The dimensions are: .43 RT, .50 LT, .74 UP, .74 DN, and .58. The callouts are: -5, -7-9, -2, and ALIGN. The text 'FILL MACHINED ENGRAVED AREAS WITH WHITE INK' is present. The drawing is labeled 'ASSEMBLY'.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
1		-1		BOTTOM	6061 FLAT BAR	1/8 x 2-3/8 x 2-3/8	1
	X	-2	1	WELDMENT		-1 & -3	1
1		-3		SUPPORT	6061 FLAT BAR	1/8 x 1 x 1-1/4	1
		-5	1	GUAGE	6061 T BAR	3/4 x 3/4 x 2-3/8	2
B/O		-7	2	ROUND HEAD MACH. SCREW	PLATED STEEL	#4-40 x 3/8	1
B/O		-9	2	NUT	PLATED STEEL	#4-40	N/S
ASSY QTY							

TITLE M/R CONTROL RIGGING AID

DWG NO. RBT18608

REV 2A

UNLESS OTHERWISE SPECIFIED

TOLERANCES ARE IN INCHES

DIMENSIONS ON DECIMALS

FRACTIONS ± 1/32

ANGLES ±.5°

TEXT *P. HILL*

FINISH RED ANODIZE

USED ON MODEL

MD 369D/E/FF - 500N

UNLESS OTHERWISE SPECIFIED

1. BREAK ALL SHARP EDGES

.015 x .457 PR .015

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SCALE NTS

DATE 7-01-05

SHEET 1 of 2

RED BARN MACHINE

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042) ☐									
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition											
Description Work Order Deviation						Completed By											
						Lead hand / Supervisor											
						QC / QA Coordinator											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044694**



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044694
PO Date: 10/4/19
Due Date: 10/16/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201036-A	RBW6522A00231-W142AJ-3T-3	RBW6522A00231-W142AJ-3T 5	Base Plate (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	10/21/19	1 pcs	0 pcs	1 pcs	\$5.51/pcs	\$5.51
	201036				Firmed	-	10/22/19	5 pcs	0 pcs	5 pcs	\$5.51/pcs	\$27.55
Sub Total:								6	0	6		\$33.06
2	181397	647.1814	647.1800	Gusset LH : Various STC's ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	10/16/19	16 pcs	0 pcs	16 pcs	\$8.76/pcs	\$140.16
3	201205	SWA3-300	SWA3-300 3	Wire Clamp (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	10/16/19	30 pcs	0 pcs	30 pcs	\$5.52/pcs	\$165.60



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PURCHASE ORDER **POHB044694**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	199122	RBT18608-2	RBT18608 2A	Weldment -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/16/19	10 pcs	0 pcs	10 pcs	\$5.51/pcs	\$55.10
5	199132	RBW6522A00231-W142S-3T	RBW6522A00231-W142S-3T 2	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Received	-	10/16/19	5 pcs	5 pcs	0 pcs	\$5.51/pcs	\$0.00

Grand Total: \$393.92

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/21/19 1:53 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918812

Date: 21-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
1 ea	Part: RBW6522A00231-W142AJ-3T-3 Base Plate Black Anodize per MIL-A-8625F, Type II, Class2, Water Sealant .0004-.0010" (4 - 1 mils). Job: 26267 PO: POHB044694		Rev: 5 Line: 1
16 ea	Part: 647.1814 Gusset LH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 26268 PO: POHB044694		Rev: A Expiry Date: 06/20 Line: 2
30 each	Part: SWA3-300 Wire Clamp Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils). Water Sealant Job: 26269 PO: POHB044694		Rev: 3 Line: 3
5 ea	Part: RBW6522A00231-W142S-3T Tail Rotor Gear Box/Mast Output Black Anodize per MIL-A-8625F, Type II, Class2, Water Sealant .0004-.0010" (4 - 1 mils). Job: 26271 PO: POHB044694		Rev: 5 Line: 5
Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918812

Date: 21-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>OCT 21 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918815

Date: 21-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 each	Part: RBT18608-2 Weldment Anodize per MIL-A-8625F, Type II, Class2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 26270 PO: POHB044694		
	Rev: _____ Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>OCT 21 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED
OCT 21 2019
DART AEROSPACE LTD.